

Split - 2

Work Order ID 86206-1

86206

Page 1

June-22-12 3:04:43 PM

Item ID: D4072-5

Accept

N9000040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Bushing

Start Date: 22/06/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Run

Start

NR1

Approvals:

Process Plan: MLJ

Date: 12/06/22 Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4072

B

100

0.00

100

Hardinge

Hardinge CNC LATHE SMALL

0.00

Hardinge CNC Lathe Small

Memo

1-Turn as per Dwg and Folio FA978

Dwg Rev: B

Folio Rev: 4A

2-Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

AS
14
9-83

12/07/30

8

8

DAS
14
9-83

12/07/30

8

8

1000

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Work Order ID 86206

86206

Page 2

June-22-12 3:04:43 PM

Item ID: D4072-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bushing

Start Date: 22/06/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

12-07-30

80 8.0

130

Identify as per dwg & Stock Location: *093*

0.00

130

Packaging

Memo

0.00

Packaging

12/1/30 (8)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/7/31
MW 12/07/30

1940

1941

1942

1943

1944

1945

1946

1947

1948

1949

1950

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1961

1962

1963

1964

1965

1966

1967

1968

Picklist Print

June-22-12 3:04:47 PM

Page 1

Work Order ID: 86206

86206

Parent Item: D4072-5

D4072-5

Parent Item Name: Bushing

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV:A NEW ISSUE 10-10-08 JLM VERIFIED BY:DD IPP
REV:B DRAWING REV. CHANGE AS PER ECN 11-598 11-07-05 JFS
VERIFIED BY:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.500		Purchased	No			100	f	263.8920	0.03	1.263158			

M303R0 500

**

303 Round Bar 0.500"

Location	Loc Qty	Loc Code
MAT028	263.892	
117143	11.34	
118509	1.36	
119009	137.705	
119616	36.737	
→ 121728	76.75	

24 on 12/07/20

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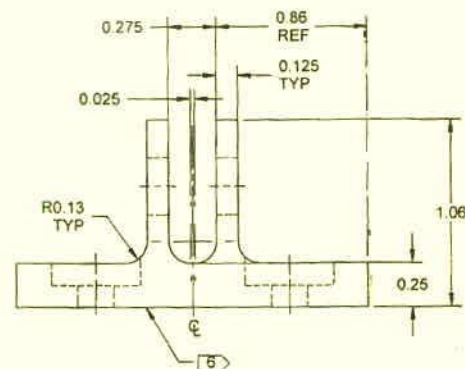
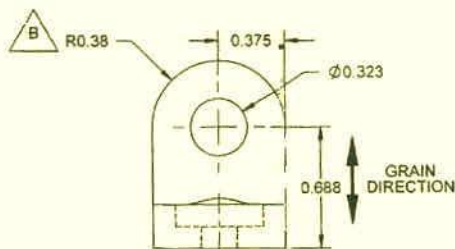
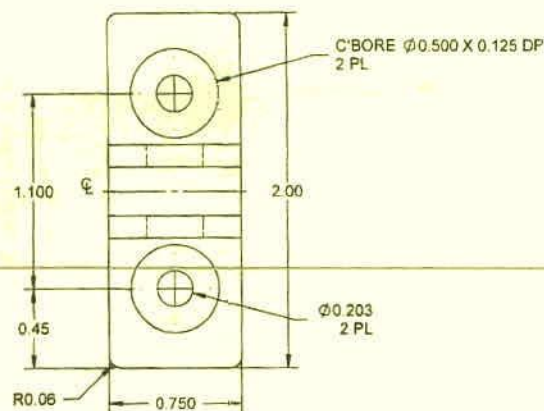
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WITHOUT NOTICE
WORK ORDER

NO. *86206 MJS*
12/06/22

D4072-1 AIRFRAME HINGE

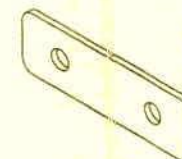
RELEASED
2011-06-30
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NOTES:

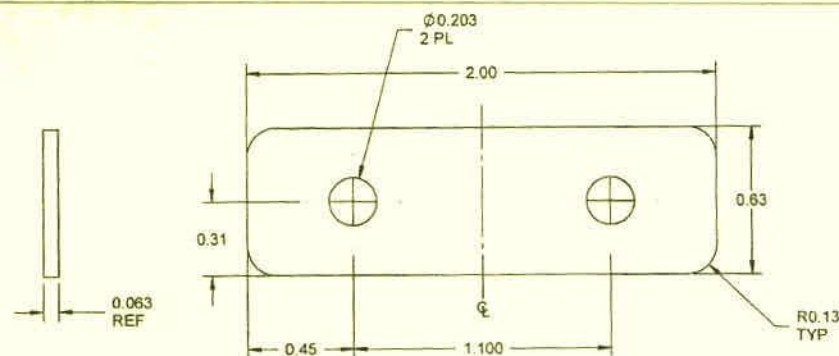
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T82 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMD 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

B	CORRECT TYPO (ZN 87-1)	RF	10.11.02
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>RF</i>	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA.	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D4072	SHEET 1 OF 3
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	AIRFRAME HINGE	NTS
DATE	10.11.02	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	





86206



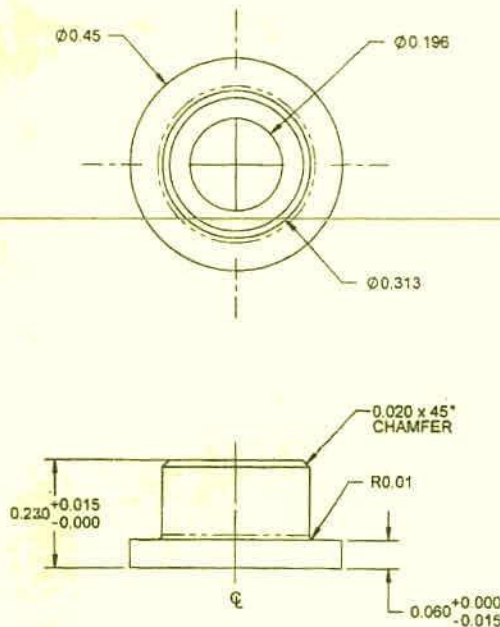
D4072-3 AIRFRAME HINGE BACKING PLATE

RELEASED
2011-06-30

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA:	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4072	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
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D4072-5 BUSHING



860706

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2011-06-30

NOTES

- 1) MATERIAL: AISI 303 STAINLESS STEEL BAR
REF DART SPEC. M303B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.004 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4072	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AIRFRAME HINGE	NTS
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